

Work Order ID 56884

March 12, 2010 10:04:01 AM

Page 1

Item ID: D3705-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Instrument Panel Assembly

Start Date: 3/12/10 Start Qty: 5.00

Cust Item ID:

Required Date: 3/22/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-3-12

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3705	Rev C								
100	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- install parts as per dwg D3705								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

= 7 m. h w/04/14

8106415

PP 10/4/16 5

PPP 57755

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3705-041

Accept



Setup Start



Revision ID:

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Item Name: Instrument Panel Assembly

Start Date: 3/12/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/22/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/19 JD

Pl 10-4-06
5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 10:03:58 AM

Page 1

Work Order ID: 56884

Parent Item: D3705-041

Parent Item Name: Instrument Panel Assembly

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
IPP rev:B 09-01-09 rev.C as per dwg DD verified by:ec
IPP Rev:C 09-01-15 rivet chg DD verified by:EC

Start Date: 3/12/10

Required Date: 3/22/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN526C1032R6		Purchased	No				Each	776.0000	20.0000			



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST328

776

1892

776

Each

0.0000

5.0000

AN960JD416

NAS1149084-3 J Per SST off

Purchased

No

M 113700

X



Washer

CR1122-3-02.5

Purchased

No

Each

86.0000

140.0000



RIVET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311

86

106878

1

110849 ✓

7

111293

3

113235 ✓

75

M 114378 ✓

M-k
20
10/04/14
M-k 10/04/14

X
M-k
75
58
10/04/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.04.14	100	Perm. change Need NAS 1149 DO 5435 MM113706 IN LIEU OF AN960416	SD	10/04/14	3	10.04.14 S. L. O. R.	S 10/04/15	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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March 12, 2010 10:03:58 AM

Page 2

Work Order ID: 56884



Parent Item: D3705-041



Parent Item Name: Instrument Panel Assembly

Start Date: 3/12/10

Required Date: 3/22/10

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
IPP rev:B 09-01-09 rev.C as per dwg DD verified by:ec
IPP Rev:C 09-01-15 rivet chg DD verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3335-1		Manufactured	No				Each	11.0000	5.0000			



Short Spring



Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	11	
	44245	1	
	45179	8	
	55804	2	

D3705-043

Manufactured No



Instrument Panel Weldment

D3705-5

Manufactured No



Access Panel

B 56886

Each 0.0000 5.0000



Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST084	9	
	54825	9	

3
M-L
10/04/14
2
8/10/04/12
S

5
M-L
10/04/14

March 12, 2010 10:03:58 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Parent Item Name: Instrument Panel Assembly

Start Date: 3/12/10

Required Date: 3/22/10

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
IPP rev:B 09-01-09 rev.C as per dwg DD verified by:ec
IPP Rev:C 09-01-15 rivet chg DD verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3706-5		Manufactured	No				Each	5.0000	5.0000			



Pin

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST084	5	
	44852	3	
	46111	2	

m-h
10/04/14

D3707-3

Manufactured No



MOUNTING LUG

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST084	8	
	55456	8	

m-h
10/04/14

MS171498

Purchased No



Spring Pin

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST314	51	
	108521	51	

m-h
10/04/14

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Page 3

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Picklist Print

Page 4

March 12, 2010 10:03:59 AM

Work Order ID: 56884

Parent Item: D3705-041

Parent Item Name: Instrument Panel Assembly

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
IPP rev:B 09-01-09 rev.C as per dwg DD verified by:ec
IPP Rev:C 09-01-15 rivet chg DD verified by:EC

Start Date: 3/12/10

Required Date: 3/22/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21075L3		Purchased	No				Each	20.0000	5.0000			
												
Nutplate												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse	4114227	
ST303	20	
112991	13	
113734	7	

MS24693-C272	Purchased	No	Each	1,392.000	5.0000
--------------	-----------	----	------	-----------	--------



Screw

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST310	1392	
17137	519	
17831	520	
8814	3	
8815	31	
9063	19	
9370	300	

70x m-h 10/04/14

20 m-h 10/04/14

March 12, 2010 10:03:59 AM

Shop Packet Print

Page 4

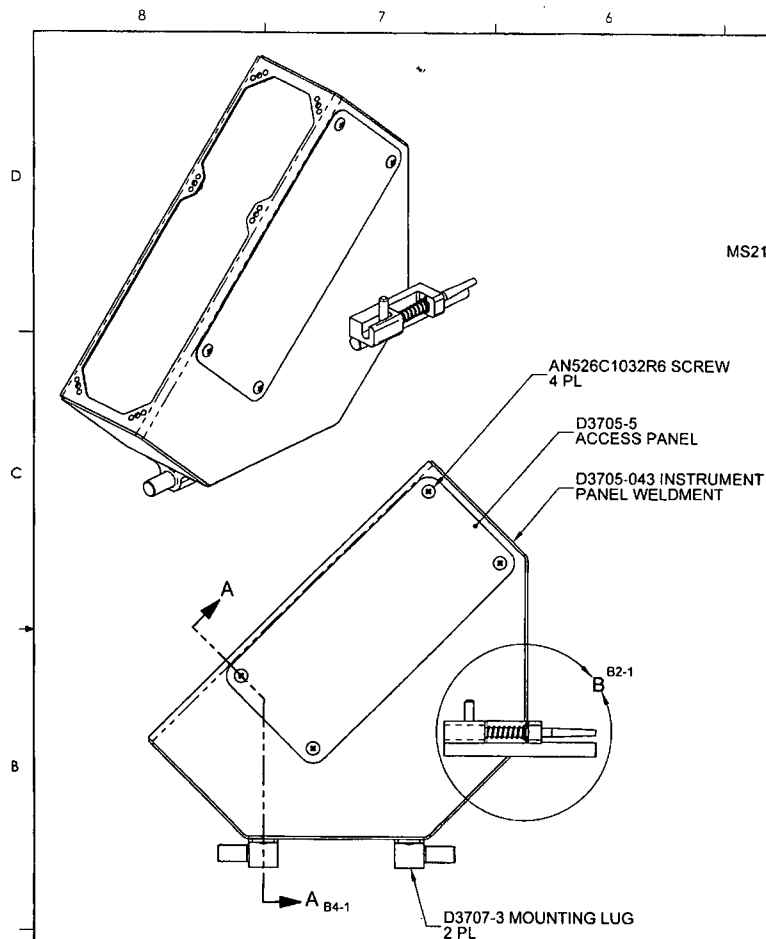
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

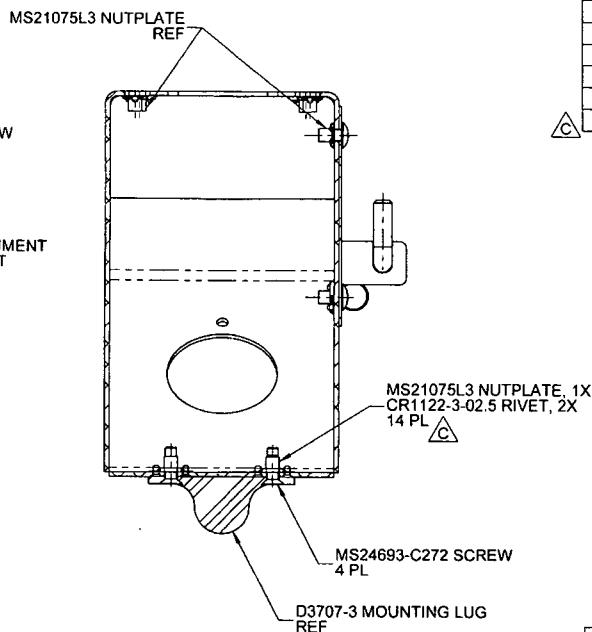
NOTE: Date & initial all entries



D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.97 lbs

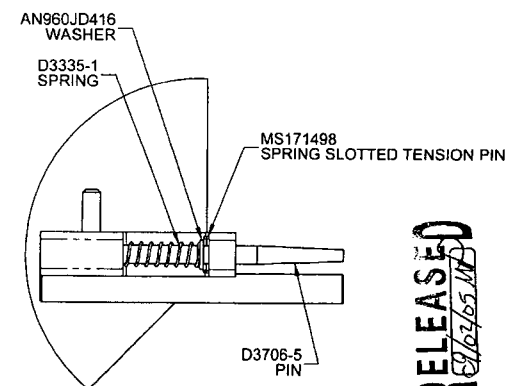


SECTION A-A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 56894

ITEM	QTY	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET



DETAIL B
SCALE 2X

C	ADDED D3705-7/9-11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3); 0.1.90 WAS 1.50 (ZN D5-4); ADDED 0.0204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156; QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-08 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DRAWN			
CHECKED	ASS		
MFG. APPR.	DS		
APPROVED	AD		
DE APPR.			
DATE	08.11.20		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3705

TITLE

INSTRUMENT PANEL ASS'Y

SCALE

NTS

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RELEASED
18/02/05

Bulldog-3-12

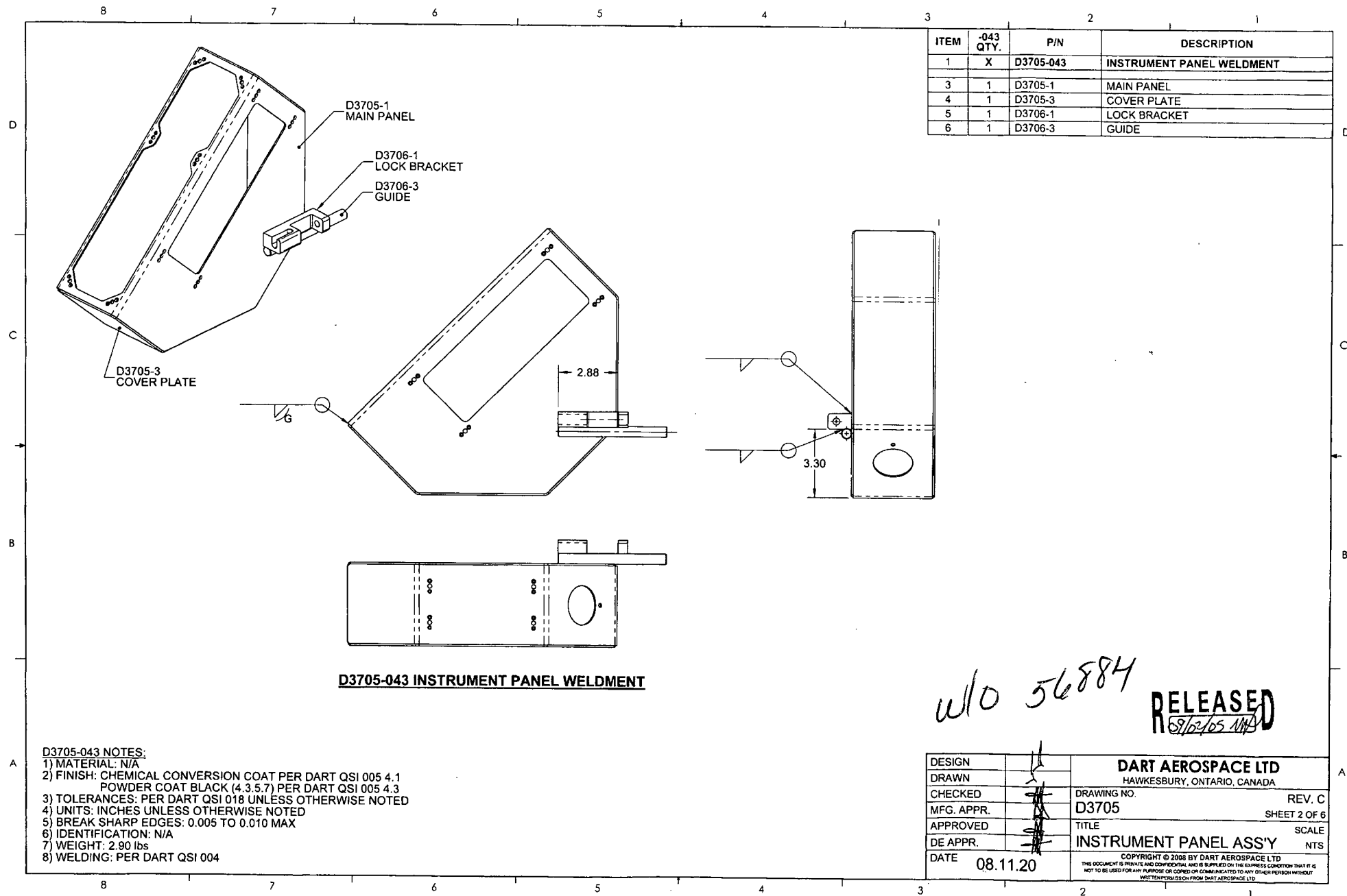
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

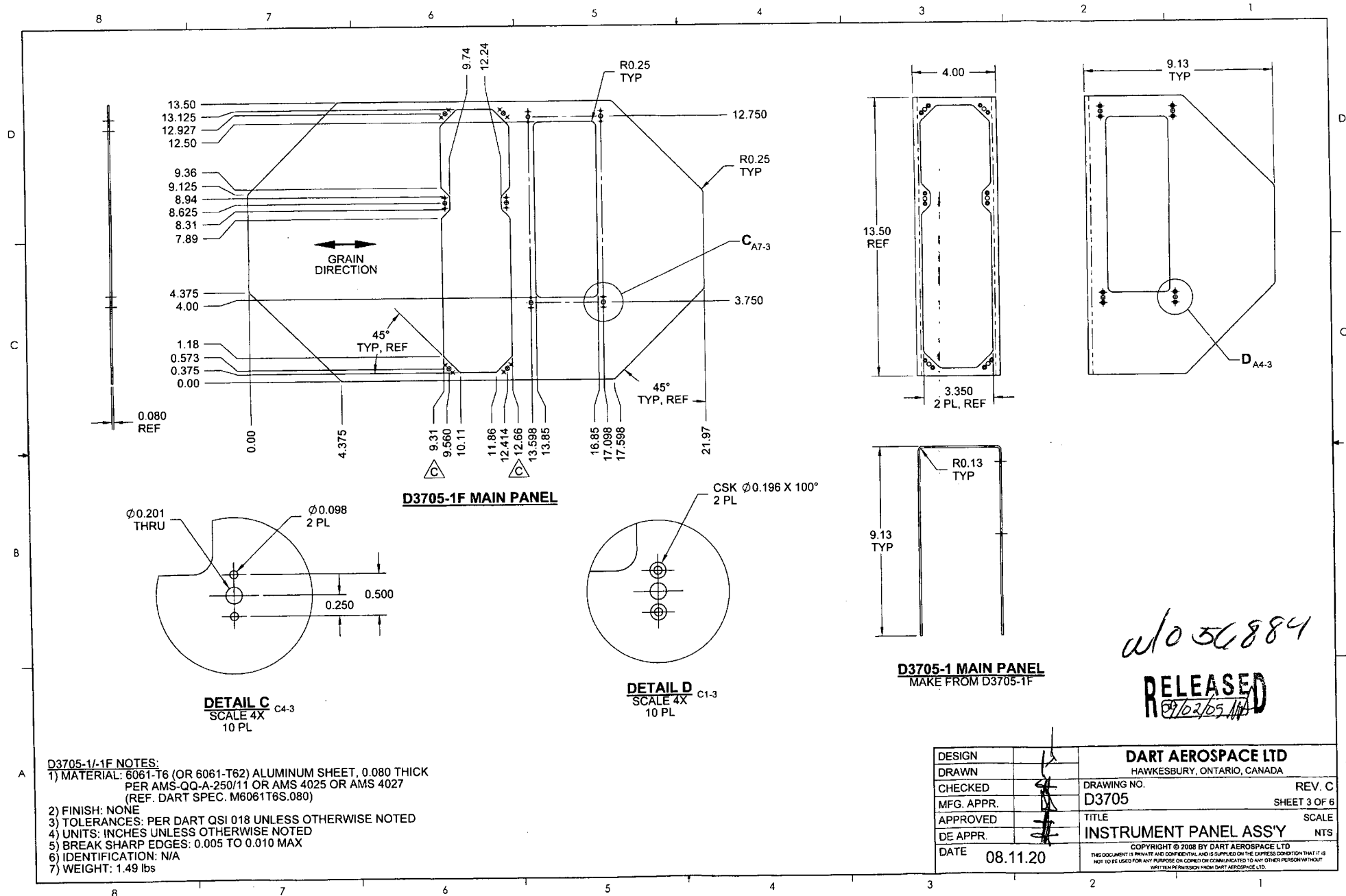
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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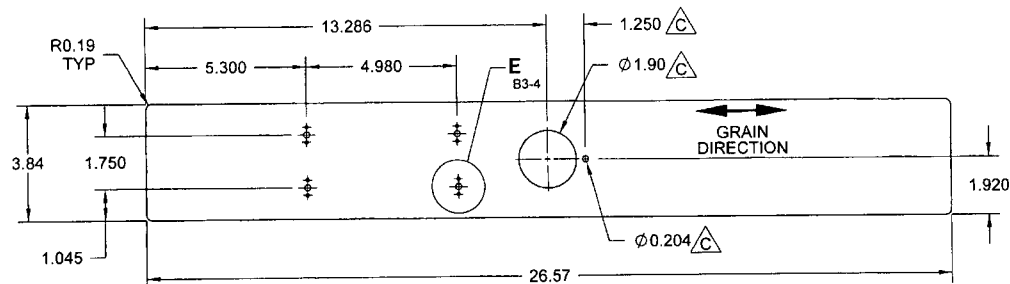
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

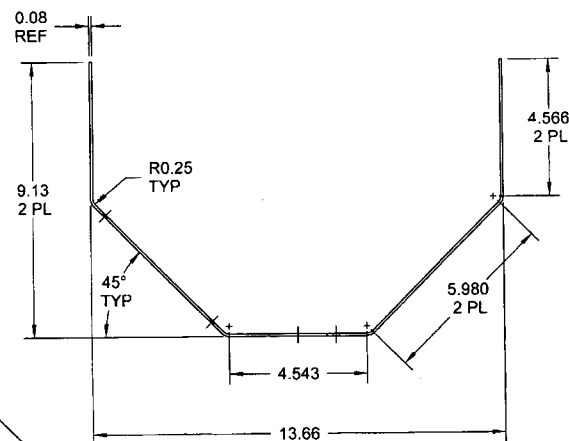
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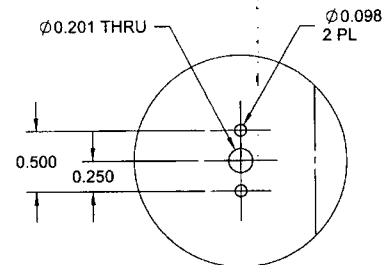
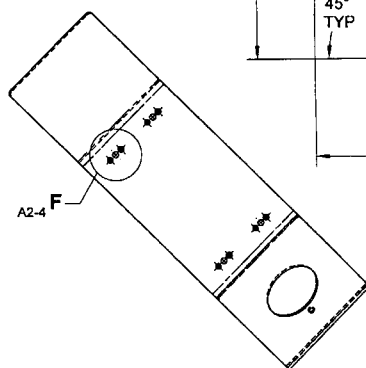
NOTE: Date & initial all entries



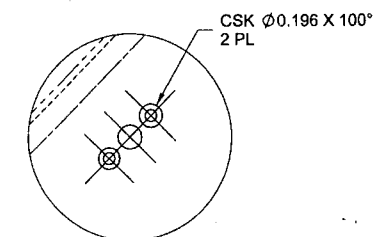
D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



DETAIL E
SCALE 4X
4 PL



DETAIL F
SCALE 4X
4 PL

RELEASED
09/02/05

D3705-3/3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.77 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3705	REV. C
MFG. APPR.		TITLE	SCALE
APPROVED		INSTRUMENT PANEL ASS'Y	NTS
DE APPR.		DATE	08.11.20
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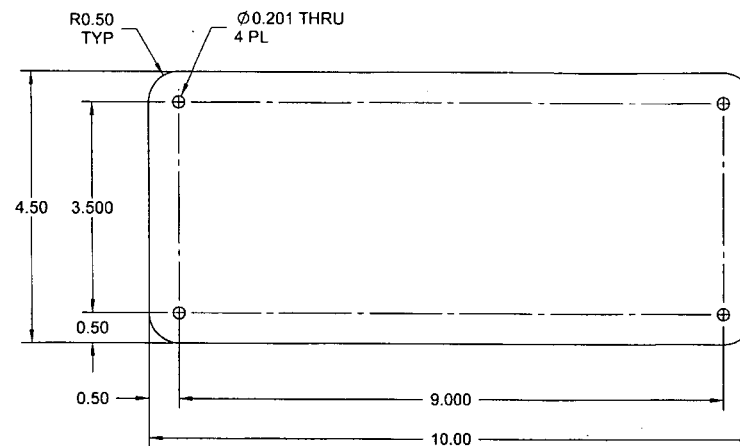
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



0.040
REF

D3705-5 ACCESS PANEL

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3705	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.11.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O 5684 RELEASED
9/10/05 M/D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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